

ASAP

Dart Aerospace Ltd.

Date: Wednesday, 06/08/2008 2:08:41 PM
 User: Julie Lecocq

Process Sheet

SPLIT-2

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 41038 - 2
 Estimate Number : 12576
 P.O. Number :
 This Issue : 06/08/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : // Type : LARGE FAB ASSY
 Previous Run : 40288
 Drawing Name : STEP WELDMENT
 Part Number : D3562041
 Drawing Number : D3562 REV E
 Project Number : N/A
 Drawing Revision : E
 Material :
 Due Date : 29/08/2008 Qty: 3 Um: Each
 Written By :
 Checked & Approved By : JUP 08.8.06
 Comment : Est Rev:A New Issue 06-11-09 JLM
 Est rev B ECN 987 07.10.09 EC verified by: DD
 Est Rev:C ECN1048 07-12-18 DD verified by:ec
 Est Rev:D 08-07-28 add chemical conversion coat DD
 verified by:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0

D2622120C

Step Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Qty Part # Description Batch:
 1 D2622-120C Extrusion 40937

Check Material for any Dents or Defects

2.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622 extrusion as per Dwg D3562

2-Deburr and bevel ends for welding

3.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

HS

08.09.03

(25)

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Drawing Name: STEP WELDMENT

Job Number: 41038

Part Number: D3562041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

6.0

D3560041

Arm Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

ARM WELDMENT

Batch:

3 40299



B40299(1)

SAD 09-01-07 (3)

(2x)

7.0

D3560043

Arm Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

ARM WELDMENT

Batch:

3 40300

B35297 (1)

SAD 09-01-07 (3)

(2x)

8.0

MS20600AD4W5

Blind Rivet



Comment: Qty.: 32.0000 Each(s)/Unit Total: 160.0000 Each(s)

Blind Rivet

batch:

M110890

M110427

SAD 09-01-09

(2x)

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Transfer drill Rivet holes as per dwg D3562.

2-Touch-up rivet holes with alodine as per dwg d3562

3-Rivet legs using Magnabond as per dwg D3562.

*****Ensure to wipe off any excess magnabond *****

A/R Magnabond 6398

Batch:

M110695

~~SP 08-09-08 (2x)~~

~~SP 08-09-08 (2x)~~

~~SP 08-09-08 (2x)~~

SAD 09-01-09 (3)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/01/09 (3)

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 41038

Part Number: D3562041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D2734

Step End Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D2734

End Cap

339119

SE 09-01-09 3

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld end caps as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024.

A/R Aluminum Rod M108037

SE 09-01-09 3

2-Grind end cap welds flush as per Dwg D3562

SAD 09-01-09 3

13.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

BF 09-01-09 3

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/01/09 3

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-H 09/01/10

3X

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10:20
320°F
10:50

M-H 09/01/10

3X

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Drawing Name: STEP WELDMENT

Job Number: 41038

Part Number: D3562041

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3562 and QSI 005 4.4

Batch: *m 109917*

FL 09/01/12 (3)

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

CP 09/01/13 (3)

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Assembly Kit

G-A

CP 09/01/13 (3)

20.0

QC21

FINAL INSPECTION/W/O RELEASE



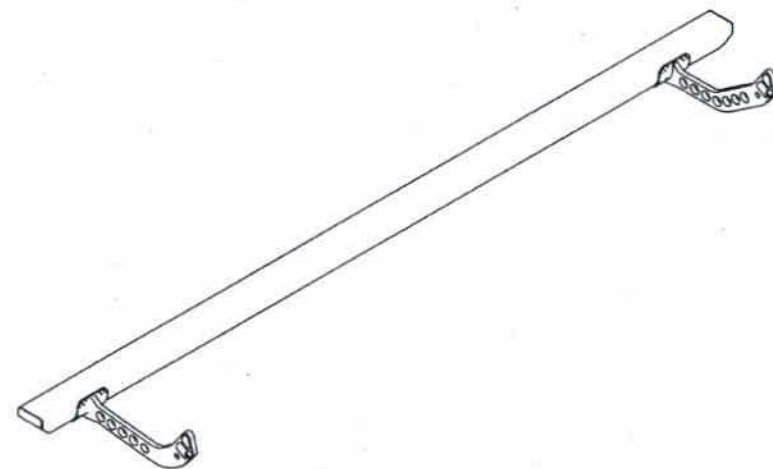
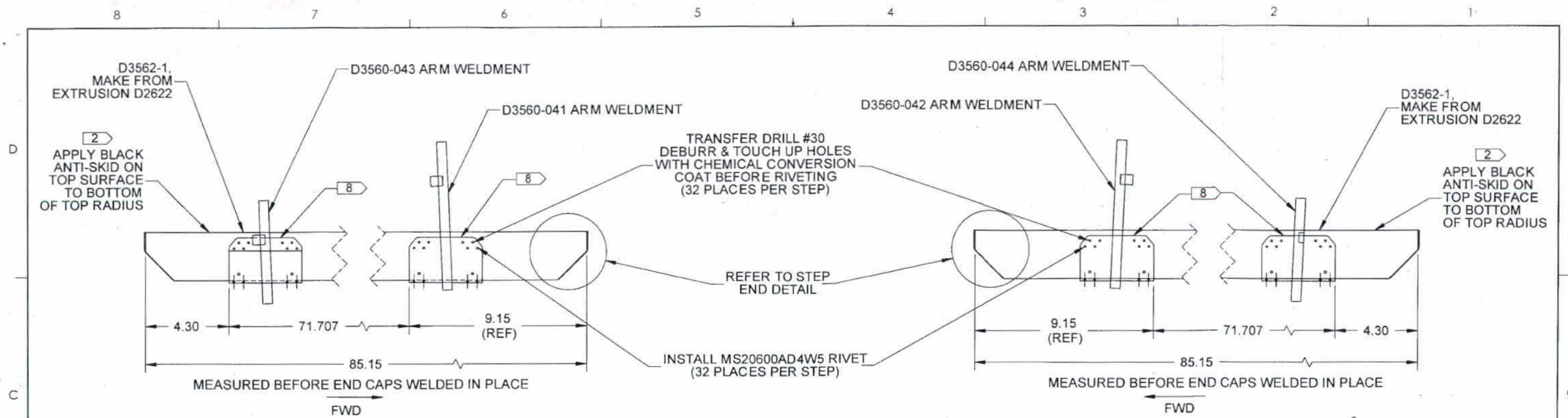
Comment: FINAL INSPECTION/W/O RELEASE

09/01/14

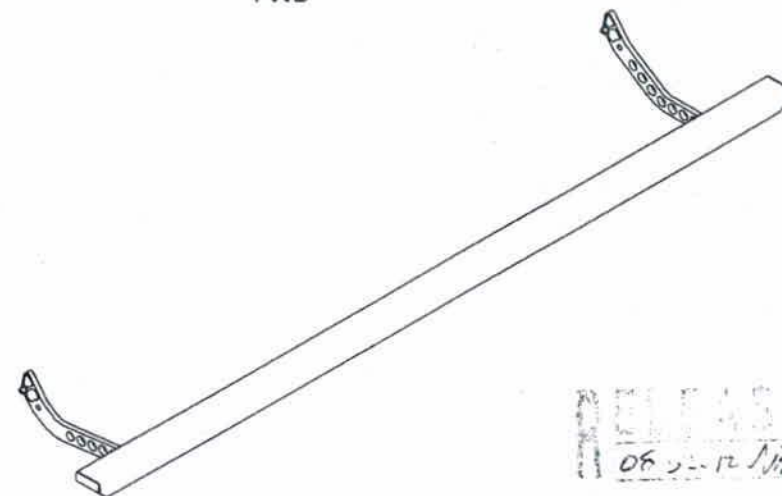
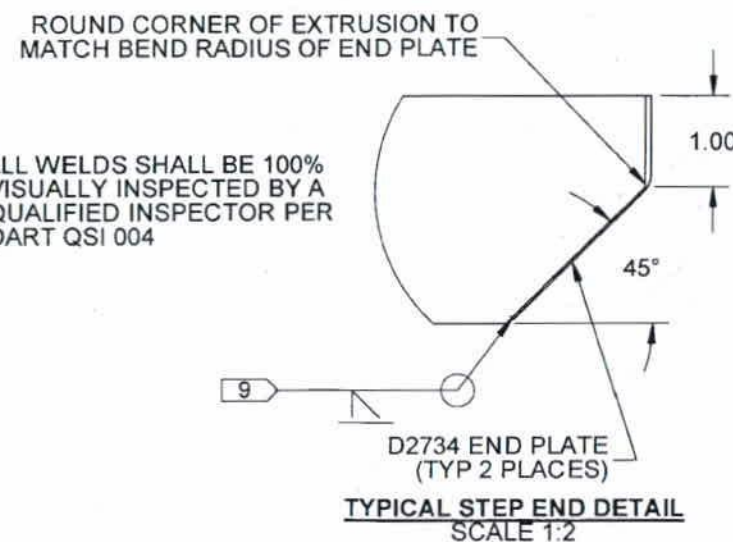
Job Completion



MF 09-1-13



D3562-041 LH STEP ASSEMBLY



D3562-042 RH STEP ASSEMBLY

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH:
 - i) CHEMICAL CONVERSION COAT STEP EXTRUSION PER DART QSI 005 4.1 BEFORE ASSEMBLY
 - ii) POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
 - iii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 8.79 lbs
 - 8) INSTALL ARM WELDMENTS WITH A LAYER OF MAGNOBOND 6398 BETWEEN THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH MAGNOBOND 6398. CLEAN OFF EXCESS BEFORE POWDER COATING.
 - 9) WELDING: PER DART QSI 004

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3562-041	LH STEP ASSEMBLY
	X	D3562-042	RH STEP ASSEMBLY
1		D3560-041	ARM WELDMENT
	1	D3560-042	ARM WELDMENT
1		D3560-043	ARM WELDMENT
	1	D3560-044	ARM WELDMENT
32	32	MS20600AD4W5	RIVET
2	2	D2734	END PLATE

E	ADD QTY (2) TO D2734 END PLATE ON D3562-042	PH	08.01.11
D	REMOVE D2808 SPACER NOTE; REDRAWN IN SOLIDWORKS	DC	07.11.16
C	NOW MAGNOBOND, ADD D2808, REMOVE 4 RIVETS	CP	07.06.19
B	ARMS NOW RIVETED TO STEP	CP	07.01.15
A	NEW ISSUE	CP	06.09.26
REV.	DESCRIPTION	BY	DATE

DESIGN	GP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	EG		
CHECKED	LE	DRAWING NO.	REV. E
MFG. APPR.		D3562	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		STEP ASSEMBLY	1:5
DATE	08.01.11	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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